

Work Order ID 80063

80063

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February-09-12 12:48:42 PM

Item ID: D2569 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Hinge
 Start Date: 09/02/2012 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 23/02/2012 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: M.L.J. Date: 12/02/09 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2569 | Rev B |

| | | | | | | | | | |
|-----|--|------|--|--|--|--|--|--|--|
| 100 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
|-----|--|------|--|--|--|--|--|--|--|

100

Powdercoat Memo 0.00

Powder Coating Note: Advise that hinges are to be broken back and forth immediately after to ensure free mobility of hinge.

START TIME: 7:40 FINISH TIME: 8:10

OVEN TEMPERATURE 320°F

| | | | | | | | | | |
|-----|--------------------------|------|--|--|--|--|--|--|--|
| 110 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
|-----|--------------------------|------|--|--|--|--|--|--|--|

110

QC Memo 0.00

Quality Control

| | | | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|
| 120 | Identify as per dwg & Stock Location: <u>481A</u> | 0.00 | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|

120

Packaging Memo 0.00

Packaging

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 80063***80063***

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Item ID: D2569

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hinge

Start Date: 09/02/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/5/7
MLJ 12/05/03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 80063

80063

Parent Item: D2569

D2569

Parent Item Name: Hinge

Start Date: 09/02/2012

Required Date: 23/02/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP D01.12.17Changed processEC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MS20257-3-7200 | | Purchased | No | | | 100 | f | 76.7800 | 1 | 2 | | | |

MS20257-3-7200

Piano Hinge

**

Handwritten signature/initials

Location

Loc Qty

Loc Code

ST489A

76.78

119638

16.78

120521

60

725521

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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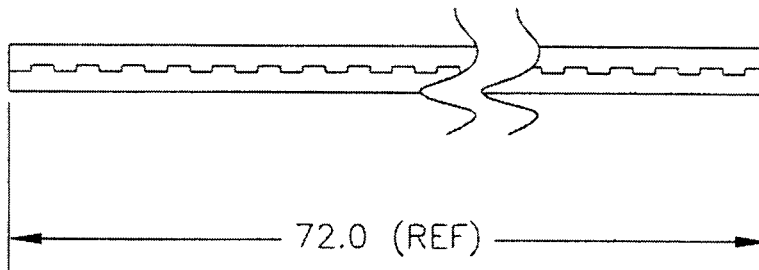
NOTE: Date & initial all entries



| | | | |
|----------------------|-----------------------|--|------------------------|
| DESIGN <i>KE</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>DA</i> | DRAWING NO. D2569 | REV. 8 SHEET 1 OF 1 |
| DATE 99.01.05 | | TITLE HINGE | SCALE 1:4 |
| A | 96.06.24 | NEW ISSUE | |
| B | 99.01.05 | ADDED MS20257-3-7200 AND P/C REMOVED HOLE PATTERN | |

RELEASED
49.01.21 KE

Y
S
G
COPY
ENT
80063 M.C.J
12/02/09



NOTES:

- 1) MAKE FROM MS20257-3-7200
- 2) POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ENSURE HINGE MOVEMENT IS MAINTAINED IMMEDIATELY AFTER POWDER COAT
- 4) USE 0.040 LOCKWIRE TO SECURE HINGE PIN AT BOTH ENDS (USE #60 DRILL FOR LOCKWIRE HOLE)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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